



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200  
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**D206-642-341BL**  
**Job Sheet 203160**



Part No: D206-642-341BL

Job Qty: 1 pcs

Part Name: Replacement Skidtubes (Fits LH or RH)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/11/19

Job Tracking No:

Due Date: 11/29/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D2650 REV.F(DEO) IPP Rev: H 05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM IPP Rev: I 08-09-29 revF as per dwg DD verified by: EC Est Rev: J 09-03-02 as per DSI9440 rev.a DD verified by: EC IPP rev K 10.08.03 chg ms27039-1-08 for "C" type EC ver: DD IPP Rev: L 12.11.22 now swage per ecn12-679 DD ver: JLM IPP Rev: M 14.04.25 ECN14-520 DD ver: JLM IPP REV: N 15.10.09 ADDED BL DD VER: JLM IPP REV: O 16.01.22 PAR16-484 DD VER: JLM

Ship Via:

### Bill of Materials

### Job Routing

| Op No | Operation     | Qty      | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off                                                     |
|-------|---------------|----------|------------|----------|-----------|---------|-----------------------|-----------|--------------------------------------------------------------|
|       |               |          |            |          | Setup Hrs | Run Hrs | Workcenter / Supplier | Lead Time |                                                              |
| 110   | Skidtubes - 1 | 1<br>pcs | 11/29/19   |          | 0.00      | 1.58    | Skidtubes - 1         |           | <i>MMA</i><br><i>TE</i><br><i>DF</i>                         |
|       |               |          |            |          |           |         | Skidtubes - 2         |           |                                                              |
|       |               |          |            |          |           |         | Skidtubes - 3         |           |                                                              |
|       |               |          |            |          |           |         | Skidtubes - 4         |           |                                                              |
|       |               |          |            |          |           |         | Skidtubes - 5         |           |                                                              |
|       |               |          |            |          |           |         | Skidtubes - 6         |           |                                                              |
|       |               |          |            |          |           |         | Skidtubes - 7         |           |                                                              |
| 115   | QC 5          | 1<br>pcs | 11/29/19   |          | 0.00      | 0.00    | QC 5 - 10             |           | <i>DAS</i><br><i>NOV 25 2019</i><br><i>68</i><br><i>9-89</i> |
|       |               |          |            |          |           |         | QC 5 - 12             |           |                                                              |
|       |               |          |            |          |           |         | QC 5 - 17             |           |                                                              |
|       |               |          |            |          |           |         | QC 5 - 18             |           |                                                              |
|       |               |          |            |          |           |         | QC 5 - 19             |           |                                                              |
|       |               |          |            |          |           |         | QC 5 - 22             |           |                                                              |
|       |               |          |            |          |           |         | QC 5 - 24             |           |                                                              |
|       |               |          |            |          |           |         | QC 5 - 3              |           |                                                              |
|       |               |          |            |          |           |         | QC 5 - 43             |           |                                                              |
|       |               |          |            |          |           |         | QC 5 - 49             |           |                                                              |
|       |               |          |            |          |           |         | QC 5 - 51             |           |                                                              |
|       |               |          |            |          |           |         | QC 5 - 58             |           |                                                              |
|       |               |          |            |          |           |         | QC 5 - 68             |           |                                                              |
|       |               |          |            |          |           |         | QC 5 - 9              |           |                                                              |
|       |               |          |            |          |           |         | QC 5 - 50             |           |                                                              |
|       |               |          |            |          |           |         | QC 5 - 30             |           |                                                              |
|       |               |          |            |          |           |         | QC 5 - 40             |           |                                                              |
|       |               |          |            |          |           |         | QC 5 - 61             |           |                                                              |
|       |               |          |            |          |           |         | QC 5 - 81             |           |                                                              |
| 116   | QC 9          | 1<br>pcs | 11/29/19   |          | 0.00      | 0.00    | QC 9 - 10             |           |                                                              |
|       |               |          |            |          |           |         | QC 9 - 18             |           |                                                              |



Container No: S234427



Part: D206-642-341BL

Job No: 203160

Serial No/Batch: S234427

Revision: F(deo)

Inspector:

Exp Date:

Instructions: FAA STC SA004753E 18/10/17, FAA STC SH98-

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www.dartaero.com

Plex 11/11/19 1:13 PM Dart.lajeunesse.marie

|                                   |       |          |           |                           |              |
|-----------------------------------|-------|----------|-----------|---------------------------|--------------|
| 120 Handfinish - 1-1 Chemical-B4B | 1 pcs | 11/29/19 | 0.00 1.17 | QC 9 - 24                 | CPL          |
|                                   |       |          |           | QC 9 - 43                 |              |
|                                   |       |          |           | QC 9 - 50                 |              |
|                                   |       |          |           | QC 9 - 9                  |              |
|                                   |       |          |           | Handfinish - 1 - 1 - B4B  | BEB 19-11-25 |
|                                   |       |          |           | Handfinish - 1 - 2 - B4B  |              |
|                                   |       |          |           | Handfinish - 1 - 3 - B4B  |              |
|                                   |       |          |           | Handfinish - 1 - 4 - B4B  |              |
|                                   |       |          |           | Handfinish - 1 - 5 - B4B  |              |
|                                   |       |          |           | Handfinish - 1 - 6 - B4B  |              |
|                                   |       |          |           | Handfinish - 1 - 7 - B4B  |              |
|                                   |       |          |           | Handfinish - 1 - 8 - B4B  |              |
|                                   |       |          |           | Handfinish - 1 - 9 - B4B  |              |
|                                   |       |          |           | Handfinish - 1 - 10 - B4B |              |
|                                   |       |          |           | Handfinish - 1 - 11 - B4B |              |
|                                   |       |          |           | Handfinish - 1 - 12 - B4B |              |
|                                   |       |          |           | Handfinish - 1 - 13 - B4B |              |
|                                   |       |          |           | Handfinish - 1 - 14 - B4B |              |
|                                   |       |          |           | Handfinish - 1 - 15 - B4B |              |
|                                   |       |          |           | Handfinish - 1 - 16 - B4B |              |
|                                   |       |          |           | Handfinish - 1 - 17 - B4B |              |
|                                   |       |          |           | Handfinish - 1 - 18 - B4B |              |
| 125 QC 7                          | 1 pcs | 11/29/19 | 0.00 0.00 | Handfinish - 1 - 19 - B4B |              |
|                                   |       |          |           | Handfinish - 1 - 20 - B4B |              |
|                                   |       |          |           | Handfinish - 1 - 21 - B4B |              |
|                                   |       |          |           | Handfinish - 1 - 22 - B4B |              |
|                                   |       |          |           | QC 7 - 10                 |              |
|                                   |       |          |           | QC 7 - 13                 |              |
|                                   |       |          |           | QC 7 - 14                 |              |
|                                   |       |          |           | QC 7 - 15                 |              |
|                                   |       |          |           | QC 7 - 17                 |              |
|                                   |       |          |           | QC 7 - 18                 |              |
|                                   |       |          |           | QC 7 - 19                 |              |
|                                   |       |          |           | QC 7 - 2                  |              |
|                                   |       |          |           | QC 7 - 28                 |              |
|                                   |       |          |           | QC 7 - 3                  |              |
|                                   |       |          |           | QC 7 - 30                 |              |
|                                   |       |          |           | QC 7 - 34                 |              |
|                                   |       |          |           | QC 7 - 36                 |              |
|                                   |       |          |           | QC 7 - 37                 |              |
|                                   |       |          |           | QC 7 - 41                 |              |
|                                   |       |          |           | QC 7 - 47                 |              |
|                                   |       |          |           | QC 7 - 48                 |              |
|                                   |       |          |           | QC 7 - 51                 |              |
|                                   |       |          |           | QC 7 - 58                 |              |
|                                   |       |          |           | QC 7 - 59                 |              |
|                                   |       |          |           | QC 7 - 60                 |              |
|                                   |       |          |           | QC 7 - 9                  |              |

|                         |          |          |           |                     |    |
|-------------------------|----------|----------|-----------|---------------------|----|
|                         |          |          |           | QC 7 - 68           |    |
|                         |          |          |           | QC 7 - 50           |    |
|                         |          |          |           | QC 7 - 67           |    |
|                         |          |          |           | QC 7 - 40           |    |
|                         |          |          |           | QC 7 - 24           |    |
|                         |          |          |           | QC 7 - 43           |    |
|                         |          |          |           | QC 7 - 61           |    |
|                         |          |          |           | QC 7 - 81           |    |
|                         |          |          |           | QC 7 - 76           |    |
|                         |          |          |           | QC 7 - 79           | 00 |
| 130 Skidtubes - 2 - B4B | 1<br>pcs | 11/29/19 | 0.00 1.58 | Skidtubes - 1 - B4B |    |
|                         |          |          |           | Skidtubes - 2 - B4B |    |
|                         |          |          |           | Skidtubes - 3 - B4B |    |
|                         |          |          |           | Skidtubes - 4 - B4B | TF |
|                         |          |          |           | Skidtubes - 5 - B4B |    |
|                         |          |          |           | Skidtubes - 6 - B4B |    |
|                         |          |          |           | Skidtubes - 7 - B4B |    |
| 140 QC 5                | 1<br>pcs | 11/29/19 | 0.00 0.00 | QC 5 - 10           |    |
|                         |          |          |           | QC 5 - 12           |    |
|                         |          |          |           | QC 5 - 17           |    |
|                         |          |          |           | QC 5 - 18           | BE |
|                         |          |          |           | QC 5 - 19           |    |
|                         |          |          |           | QC 5 - 22           |    |
|                         |          |          |           | QC 5 - 24           |    |
|                         |          |          |           | QC 5 - 3            |    |
|                         |          |          |           | QC 5 - 43           |    |
|                         |          |          |           | QC 5 - 49           |    |
|                         |          |          |           | QC 5 - 51           |    |
|                         |          |          |           | QC 5 - 58           |    |
|                         |          |          |           | QC 5 - 68           |    |
|                         |          |          |           | QC 5 - 9            |    |
|                         |          |          |           | QC 5 - 50           |    |
|                         |          |          |           | QC 5 - 30           |    |
|                         |          |          |           | QC 5 - 40           |    |
|                         |          |          |           | QC 5 - 61           |    |
|                         |          |          |           | QC 5 - 81           |    |
| 150 Skidtubes - 3 - B4B | 1<br>pcs | 11/29/19 | 0.00 1.58 | Skidtubes - 1 - B4B |    |
|                         |          |          |           | Skidtubes - 2 - B4B |    |
|                         |          |          |           | Skidtubes - 3 - B4B |    |
|                         |          |          |           | Skidtubes - 4 - B4B | TF |
|                         |          |          |           | Skidtubes - 5 - B4B |    |
|                         |          |          |           | Skidtubes - 6 - B4B |    |
|                         |          |          |           | Skidtubes - 7 - B4B |    |
| 180 QC 5                | 1<br>pcs | 11/29/19 | 0.00 0.00 | QC 5 - 10           |    |
|                         |          |          |           | QC 5 - 12           |    |
|                         |          |          |           | QC 5 - 17           |    |
|                         |          |          |           | QC 5 - 18           |    |
|                         |          |          |           | QC 5 - 19           |    |
|                         |          |          |           | QC 5 - 22           |    |
|                         |          |          |           | QC 5 - 24           |    |
|                         |          |          |           | QC 5 - 3            |    |
|                         |          |          |           | QC 5 - 43           |    |
|                         |          |          |           | QC 5 - 49           |    |
|                         |          |          |           | QC 5 - 51           |    |
|                         |          |          |           | QC 5 - 58           |    |
|                         |          |          |           | QC 5 - 68           |    |
|                         |          |          |           | QC 5 - 9            |    |
|                         |          |          |           | QC 5 - 50           |    |
|                         |          |          |           | QC 5 - 30           |    |

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NOV 27 2019 58  
9-89

|                                   |       |          |           |                           |                    |
|-----------------------------------|-------|----------|-----------|---------------------------|--------------------|
| 190 Handfinish - 2-1 Pressure-B4B | 1 pcs | 11/29/19 | 0.00 1.17 | QC 5 - 40                 |                    |
|                                   |       |          |           | QC 5 - 61                 |                    |
|                                   |       |          |           | QC 5 - 81                 |                    |
|                                   |       |          |           | Handfinish - 2 - 1 - B4B  |                    |
| 208 Spray Paint - 2 - B4B         | 1 pcs | 11/29/19 | 0.00 1.00 | Handfinish - 2 - 2 - B4B  | NOV 28 2019        |
|                                   |       |          |           | Handfinish - 2 - 3 - B4B  |                    |
|                                   |       |          |           | Handfinish - 2 - 4 - B4B  |                    |
|                                   |       |          |           | Spray Paint - 1 - B4B     | DAS 41 DEC 01 2019 |
| 210 QC 14                         | 1 pcs | 11/29/19 | 0.00 0.00 | Spray Paint - 2 - B4B     | 9-89               |
|                                   |       |          |           | Spray Paint - 3 - B4B     |                    |
|                                   |       |          |           | Spray Paint - 4 - B4B     |                    |
|                                   |       |          |           | QC 14 - 15                | 11 14-12-2         |
| 220 Handfinish - 4-1-Assembly-B4B | 1 pcs | 11/29/19 | 0.00 1.17 | QC 14 - 2                 |                    |
|                                   |       |          |           | QC 14 - 34                |                    |
|                                   |       |          |           | QC 14 - 41                |                    |
|                                   |       |          |           | QC 14 - 51                |                    |
| 240 QC 5                          | 1 pcs | 11/29/19 | 0.00 0.00 | QC 14 - 58                |                    |
|                                   |       |          |           | QC 14 - 59                |                    |
|                                   |       |          |           | QC 14 - 9                 |                    |
|                                   |       |          |           | QC 14 - 68                |                    |
|                                   |       |          |           | QC 14 - 40                |                    |
|                                   |       |          |           | QC 14 - 19                |                    |
|                                   |       |          |           | QC 14 - 43                |                    |
|                                   |       |          |           | QC 14 - 24                |                    |
|                                   |       |          |           | QC 14 - 61                |                    |
|                                   |       |          |           | QC 14 - 81                |                    |
|                                   |       |          |           | Handfinish - 4 - 1 - B4B  | 11 14-12-11        |
|                                   |       |          |           | Handfinish - 4 - 10 - B4B |                    |
|                                   |       |          |           | Handfinish - 4 - 11 - B4B |                    |
|                                   |       |          |           | Handfinish - 4 - 12 - B4B |                    |
|                                   |       |          |           | Handfinish - 4 - 13 - B4B |                    |
|                                   |       |          |           | Handfinish - 4 - 14 - B4B |                    |
|                                   |       |          |           | Handfinish - 4 - 15 - B4B |                    |
|                                   |       |          |           | Handfinish - 4 - 2 - B4B  |                    |
|                                   |       |          |           | Handfinish - 4 - 3 - B4B  |                    |
|                                   |       |          |           | Handfinish - 4 - 4 - B4B  |                    |
|                                   |       |          |           | Handfinish - 4 - 5 - B4B  |                    |
|                                   |       |          |           | Handfinish - 4 - 6 - B4B  |                    |
|                                   |       |          |           | Handfinish - 4 - 7 - B4B  |                    |
|                                   |       |          |           | Handfinish - 4 - 8 - B4B  |                    |
|                                   |       |          |           | Handfinish - 4 - 9 - B4B  |                    |
|                                   |       |          |           | QC 5 - 10                 |                    |
|                                   |       |          |           | QC 5 - 12                 |                    |
|                                   |       |          |           | QC 5 - 17                 |                    |
|                                   |       |          |           | QC 5 - 18                 |                    |
|                                   |       |          |           | QC 5 - 19                 |                    |
|                                   |       |          |           | QC 5 - 22                 |                    |
|                                   |       |          |           | QC 5 - 24                 |                    |
|                                   |       |          |           | QC 5 - 3                  |                    |
|                                   |       |          |           | QC 5 - 43                 |                    |
|                                   |       |          |           | QC 5 - 49                 |                    |
|                                   |       |          |           | QC 5 - 51                 |                    |
|                                   |       |          |           | QC 5 - 58                 |                    |
|                                   |       |          |           | QC 5 - 68                 | DAS 68 DEC 17 2019 |
|                                   |       |          |           |                           | 9-89               |
|                                   |       |          |           |                           |                    |

DAS 15 9-89



|                                 |          |          |           |                        |             |
|---------------------------------|----------|----------|-----------|------------------------|-------------|
|                                 |          |          |           | QC 5 - 9               |             |
|                                 |          |          |           | QC 5 - 50              |             |
|                                 |          |          |           | QC 5 - 30              |             |
|                                 |          |          |           | QC 5 - 40              |             |
|                                 |          |          |           | QC 5 - 61              |             |
|                                 |          |          |           | QC 5 - 81              |             |
| 250 Packaging 3-1 - Stock - B4B | 1<br>pcs | 11/29/19 | 0.00 0.00 | Packaging 3 - 1 - B4B  |             |
|                                 |          |          |           | Packaging 3 - 2 - B4B  |             |
|                                 |          |          |           | Packaging 3 - 3 - B4B  |             |
|                                 |          |          |           | Packaging 3 - 4 - B4B  |             |
|                                 |          |          |           | Packaging 3 - 5 - B4B  |             |
|                                 |          |          |           | Packaging 3 - 6 - B4B  |             |
|                                 |          |          |           | Packaging 3 - 7 - B4B  |             |
|                                 |          |          |           | Packaging 3 - 8 - B4B  |             |
|                                 |          |          |           | Packaging 3 - 9 - B4B  |             |
|                                 |          |          |           | Packaging 3 - 10 - B4B |             |
|                                 |          |          |           | Packaging 3 - 11 - B4B |             |
|                                 |          |          |           | Packaging 3 - 12 - B4B |             |
|                                 |          |          |           | Packaging 3 - 13 - B4B |             |
|                                 |          |          |           | Packaging 3 - 14 - B4B |             |
|                                 |          |          |           | Packaging 3 - 15 - B4B |             |
|                                 |          |          |           | Packaging 3 - 16 - B4B |             |
|                                 |          |          |           | Packaging 3 - 17 - B4B |             |
|                                 |          |          |           | Packaging 3 - 18 - B4B |             |
|                                 |          |          |           | Packaging 3 - 19 - B4B |             |
|                                 |          |          |           | Packaging 3 - 20 - B4B |             |
|                                 |          |          |           | Packaging 3 - 21 - B4B |             |
|                                 |          |          |           | Packaging 3 - 22 - B4B |             |
|                                 |          |          |           | Packaging 3 - 23 - B4B |             |
|                                 |          |          |           | Packaging 3 - 24 - B4B |             |
|                                 |          |          |           | Packaging 3 - 25 - B4B |             |
|                                 |          |          |           | Packaging 3 - 26 - B4B |             |
|                                 |          |          |           | Packaging 3 - 27 - B4B |             |
|                                 |          |          |           | Packaging 3 - 28 - B4B |             |
|                                 |          |          |           | Packaging 3 - 29 - B4B |             |
|                                 |          |          |           | Packaging 3 - 30 - B4B |             |
|                                 |          |          |           | Packaging 3 - 31 - B4B |             |
|                                 |          |          |           | Packaging 3 - 32 - B4B |             |
|                                 |          |          |           | Packaging 3 - 33 - B4B |             |
|                                 |          |          |           | Packaging 3 - 34 - B4B |             |
|                                 |          |          |           | Packaging 3 - 35 - B4B |             |
|                                 |          |          |           | Packaging 3 - 36 - B4B |             |
| 255 DC - 1 - B4B                | 1<br>pcs | 11/29/19 | 0.00 0.00 | DC - 1 - B4B           | DEC 24 2019 |
|                                 |          |          |           | DC - 2 - B4B           |             |
| 260 QC 21 - FG                  | 1<br>pcs | 11/29/19 | 0.00 0.00 | QC 21 - FG - 21        | DEC 24 2019 |
|                                 |          |          |           | QC 21 - FG - 70        | DAS 70      |
|                                 |          |          |           | QC 21 - FG - 53        | 9-89        |

Part Op 110 - Skid tubes 1-Deburr Fwd edge of tube 2-Scribe "Identify Batch Number" 3-Remove ridge on inside of Fwd edge of

Descriptions: tubeas per Dwg D2650 4-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required. A/R

Aluminum Rod 30913/13909 5-Grind weld flush to cap on top surface only. 6-Cut aft end to lenght as per dwg D2650

7-Drill pilot holes using drill Jig DT8168A (A,& B ) and DT8025. 8-Drill holes for wearplates using DT 8028-5. Open to Ø

0.297". 9-Open Aft Cap Hole using #6 Drill Bit 10-Open holes for Tow Ring to Ø0.625" as per Dwg D2650, D2650-5

Drilling Detail 11-Remove inner indexing ridge on aft end of skid tubeas per Dwg D2650 12- Ream holes to finished size

as per Dwg D2650, D2650-5 Drilling Detail (without cutting fluid) 13-Deburr.

115 - QC5- Inspect part completeness to step on W/O

116 - QC9- Inspect visual per QSI004- Fusion Welds

120 - Chemical Conversion Coat per QSI005 4.1

125 - QC7-Inspect Chemical Conversion Coat

130 - Skid tubes - 1- Bond D2654-5 web in place as per QSI 015 Ensure holes line up Allow 12 Hrs. cure time before

cutting Start Date: Nov 26 Time: 10:45am Finish Date: Nov 26 Time: 10:45pm A/R Sikaflex-291

5231095 Sikaflex expiry date: 03.18.2020

140 - QC5- Inspect part completeness to step on W/O

- 150 - Skid tubes - 1- Insert D4720-1 Spacer. Swage to 0.313" X 0.75" DP per QSI 002. Trim and grind flush per QSI 002
- 180 - QC5- Inspect part completeness to step on W/O
- 190 - Pressure Wash per QSI005 4.3/ Clean and remove all markings
- 208 - Prime and Paint DELFLEET BLUE as per QSI005 Prime 517332 Paint 5187836 Clear 5173359
- 210 - QC14- Inspect Spray Paint
- 220 - HandFinish4 (Assemble as per dwg - 1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate. A/R Sikaflex-291 516333J Sikaflex expiry date: 14-12-11 2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive 3-Install MS27039-4-06 Screw 4-Inspect for foreign object per QSI 024 5-Install D2646 Aft Cap and seal with SikaflexClean excess adhesive A/R Sikaflex-291 516333J Sikaflex expiry date: 14-12-11 6- Install D2680-041 Nut Plate as per Dwg D2650 7-Wing Walk as per Dwg D2650-5 and QSI 005 4.4 Batch: 5209390
- 240 - QC5- Inspect part completeness to step on W/O
- 250 - Identify and pack for shipping as per PPP D206-642-341 Location:FG083
- 255 - Document Control - Photocopy bluefile and create labels per PPP D206-642-341 CHG005
- 260 - QC21- Final Inspection- Work Order Release

Job BOM

| Part / Item   | Component Name           | Quantity       | Operation                         | Container          |
|---------------|--------------------------|----------------|-----------------------------------|--------------------|
| D2620         | Skid tube, 206 Skid tube | 1 pcs (1 ea)   | 110-Skid tubes - 1                | 5210317            |
| D2647         | Cap                      | 1 pcs (1 ea)   | 110-Skid tubes - 1                | 516609B            |
| D2654-5       | Web                      | 1 pcs (1 ea)   | 130-Skid tubes - 2 - B4B          | 5231220            |
| D4720-1       | Spacer                   | 19 pcs (19 ea) | 150-Skid tubes - 3 - B4B          | 5229621            |
| ALS4-1032-130 | Rivnut                   | 54 Ea (54 ea)  | 220-Handfinish - 4-1-Assembly-B4B | 5057757            |
| CCR264SS3-3   | Cherry Rivet             | 2 Ea (2 ea)    | 220-Handfinish - 4-1-Assembly-B4B | 522616J            |
| CR3212-4-03   | Cherry Rivet             | 2 Ea (2 ea)    | 220-Handfinish - 4-1-Assembly-B4B | 5163230-2          |
| D2646BL       | Aft Cap                  | 1 pcs (1 ea)   | 220-Handfinish - 4-1-Assembly-B4B | 5236657            |
| D2651-1BL     | Plug 516334 21x10        | 14 pcs (14 ea) | 220-Handfinish - 4-1-Assembly-B4B | 5229557            |
| D2651-3       | O-Ring 52380 52x4        | 14 pcs (14 ea) | 220-Handfinish - 4-1-Assembly-B4B | 5205351            |
| D2680-041BL   | Nut Plate 5238 215       | 1 pcs (1 ea)   | 220-Handfinish - 4-1-Assembly-B4B | 5169117            |
| D3537-1       | Wearpad 5245 79x162      | 6 pcs (6 ea)   | 220-Handfinish - 4-1-Assembly-B4B | 520450X2/S 224576A |
| D3537-3       | Wearpad                  | 1 pcs (1 ea)   | 220-Handfinish - 4-1-Assembly-B4B | 5219987            |
| D4956-11      | Wearplate Fwd            | 1 pcs (1 ea)   | 220-Handfinish - 4-1-Assembly-B4B | 5179847            |
| D4956-23      | Wearplate Center Fwd     | 1 pcs (1 ea)   | 220-Handfinish - 4-1-Assembly-B4B | 5210726            |
| D4956-35      | Wearplate Aft            | 1 pcs (1 ea)   | 220-Handfinish - 4-1-Assembly-B4B | 5209982            |
| MS27039-1-08  | Screw                    | 2 Ea (2 ea)    | 220-Handfinish - 4-1-Assembly-B4B | 5162842            |
| MS27039-4-06  | Screw                    | 1 Ea (1 ea)    | 220-Handfinish - 4-1-Assembly-B4B | 5166974-5          |
| MS27039C1-08  | Screw                    | 54 Ea (54 ea)  | 220-Handfinish - 4-1-Assembly-B4B | 5218052            |
| NAS1149C0332R | Washer (AN960C10L)       | 54 Ea (54 ea)  | 220-Handfinish - 4-1-Assembly-B4B | 5222629            |
| NAS1149D0332J | Washer                   | 2 Ea (2 ea)    | 220-Handfinish - 4-1-Assembly-B4B | 5178379            |
| NAS1149D0463J | Washer                   | 1 Ea (1 ea)    | 220-Handfinish - 4-1-Assembly-B4B | 5159585            |

Job Allocations

| Operation                         | Component Part | Required | Inventory | Allocated |
|-----------------------------------|----------------|----------|-----------|-----------|
| 110-Skid tubes - 1                | D2620          | 1        | 10        | 0         |
|                                   | D2647          | 1        | 15        | 0         |
| 130-Skid tubes - 2 - B4B          | D2654-5        | 1        | 4         | 0         |
| 150-Skid tubes - 3 - B4B          | D4720-1        | 19       | 250       | 0         |
| 220-Handfinish - 4-1-Assembly-B4B | ALS4-1032-130  | 54       | 4,866     | 0         |
|                                   | CCR264SS3-3    | 2        | 101       | 0         |
|                                   | CR3212-4-03    | 2        | 128       | 0         |
|                                   | D2646BL 4      | 1        | 1         | 0         |
|                                   | D2651-1BL 4    | 14       | 38        | 0         |
|                                   | D2651-3        | 14       | 527       | 0         |
|                                   | D2680-041BL    | 1        | 17        | 0         |
|                                   | D3537-1        | 6        | 74        | 0         |
|                                   | D3537-3        | 1        | 19        | 0         |
|                                   | D4956-11       | 1        | 5         | 0         |
|                                   | D4956-23       | 1        | 4         | 0         |
|                                   | D4956-35       | 1        | 8         | 0         |
|                                   | MS27039-1-08   | 2        | 150       | 0         |
|                                   | MS27039-4-06   | 1        | 220       | 0         |
|                                   | MS27039C1-08   | 54       | 285       | 0         |
|                                   | NAS1149C0332R  | 54       | 3,894     | 0         |
|                                   | NAS1149D0332J  | 2        | 3,674     | 0         |
|                                   | NAS1149D0463J  | 1        | 7,590     | 0         |

|                                    |
|------------------------------------|
|                                    |
| Part Specifications                |
| Specifications could not be found. |

Plex 11/11/19 1:13 PM Dart.lajeunesse.marie

















Entered: \_\_\_\_\_ Date: \_\_\_\_\_

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐

|                                |                                                                                                                                   |                                                                                                          |                                                                                                 |                                                                                          |                                                                                              |                                                                                                |  |                                                                                                                                                                |
|--------------------------------|-----------------------------------------------------------------------------------------------------------------------------------|----------------------------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------|----------------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------|--|----------------------------------------------------------------------------------------------------------------------------------------------------------------|
| Job: <u>203160</u>             | DISPOSITION<br>Rework <input checked="" type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/> | DEPARTMENT/PROCESS                                                                                       |                                                                                                 |                                                                                          |                                                                                              |                                                                                                |  | Engineering <input checked="" type="checkbox"/><br>Water Jet <input type="checkbox"/><br>Supplier <input type="checkbox"/><br>Quality <input type="checkbox"/> |
| Part No. <u>D206-642-3416L</u> |                                                                                                                                   | Skid-tube Machining Large Fab <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> | Cross tube Small Fab <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> | Eng. (Non-AW) <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> |  |                                                                                                                                                                |

|                                  |             |                |             |                                                                       |
|----------------------------------|-------------|----------------|-------------|-----------------------------------------------------------------------|
| Date :                           | Sequence #: | QTY Affected : | Disposition | Completed By<br><u>MAR</u><br>DAS 51 19/11/21<br>MRB (QS1042)<br>9-89 |
| Description Work Order Deviation |             |                |             |                                                                       |

|                                       |                                                                 |                                      |
|---------------------------------------|-----------------------------------------------------------------|--------------------------------------|
| <u>Dwg calls Ø0.625 focusing hole</u> | <u>Drill focusing hole Ø0.640</u><br><u>Ref dws D3274 Rev.9</u> | Lead hand / Supervisor<br><u>MAR</u> |
|---------------------------------------|-----------------------------------------------------------------|--------------------------------------|

QC / QA Coordinator

|                                                |                                                        |                                                          |                                             |                                            |  |  |  |  |  |  |  |  |
|------------------------------------------------|--------------------------------------------------------|----------------------------------------------------------|---------------------------------------------|--------------------------------------------|--|--|--|--|--|--|--|--|
| Root Cause                                     | FAULT CATEGORY                                         |                                                          |                                             |                                            |  |  |  |  |  |  |  |  |
| Operator <input type="checkbox"/>              | Pressure/Forced <input type="checkbox"/>               | Contamination <input type="checkbox"/>                   | Power Loss/Surge <input type="checkbox"/>   | Positioned Wrong <input type="checkbox"/>  |  |  |  |  |  |  |  |  |
| Manufacturing Process <input type="checkbox"/> | Bending <input type="checkbox"/>                       | Misaligned/off center <input type="checkbox"/>           | Folio/Program <input type="checkbox"/>      | Outside Tolerance <input type="checkbox"/> |  |  |  |  |  |  |  |  |
| Equip/Tooling <input type="checkbox"/>         | Crushing <input type="checkbox"/>                      | BOM/Route <input type="checkbox"/>                       | Grain Direction <input type="checkbox"/>    | Drawing <input type="checkbox"/>           |  |  |  |  |  |  |  |  |
| Handling/Preservation <input type="checkbox"/> | Cracks <input type="checkbox"/>                        | Broken/Damage/Defect <input type="checkbox"/>            | Weld <input type="checkbox"/>               | Finish <input type="checkbox"/>            |  |  |  |  |  |  |  |  |
| Material <input type="checkbox"/>              | Crimp/Kink/Rip/ple/Wave/Twist <input type="checkbox"/> | Incomplete/Unclear Instructions <input type="checkbox"/> | Wrong Stock Pulled <input type="checkbox"/> | Part Lost/Missing <input type="checkbox"/> |  |  |  |  |  |  |  |  |
| Product Improvement <input type="checkbox"/>   | Marks/Chatter <input type="checkbox"/>                 | Drill Holes <input type="checkbox"/>                     | Out of Sequence <input type="checkbox"/>    | Misread <input type="checkbox"/>           |  |  |  |  |  |  |  |  |
| Process Improvement <input type="checkbox"/>   | Mislabeled <input type="checkbox"/>                    | Fit/Function <input type="checkbox"/>                    | Off-set/Set-up <input type="checkbox"/>     |                                            |  |  |  |  |  |  |  |  |
| Human Factors <input type="checkbox"/>         | Other/Details:                                         |                                                          |                                             |                                            |  |  |  |  |  |  |  |  |

## Change Record

PAGE 1 OF 1

**Part Number:** D206-642-341

**Description:** REPLACEMENT SKIDTUBE LH/RH

[illegible]